

April-02-14 10:38:33 AM

1 15484

Page 1

NR2

A

DAS
30
9-89

DAS
27
9-89

9-89
4/4/14

Work Order ID 115484

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115484

Page 2

Item ID: D5076-043

Revision ID:

Item Name: Fwd Inboard Bracket Assembly

Start Date: 4/02/14 Start Qty: 5.00 ***5***

Required Date: 4/16/14 Req'd Qty: 5.00 ***5***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

140

Powdercoat

M 126878

0.00

Powder Coating

Memo

*** MASK NUT PLATE HOLES PER DWG ***

START TIME: *10:15*

OVEN TEMPERATURE: *320*

FINISH TIME: *10:45*

2 0 14-4-15

DAS 34 9-89

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

*DAS
30
9-89*

2

14/04/17

160

0.00

160

Small Fab

Memo

0.00

Small Fab

Install rubber seals and grommets.

3M 1300 batch: *127 443*

*DAS
30
9-89*

2

14/04/17

Work Order ID 115484

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Page 3

Item ID: D5076-043
Revision ID:
Item Name: Fwd Inboard Bracket Assembly
Start Date: 4/02/14 Start Qty: 5.00 ***5***
Required Date: 4/16/14 Req'd Qty: 5.00 ***5***
Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID
170
170
QC
Quality Control

Operation
Description
QC5- Inspect part completeness to step on W/O

Memo

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00				2			
0.00							

180
180
Packaging
Packaging

Identify as per dwg & Stock Location: GA

Memo

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00			DAS 30 9-89	2			14/04/17
0.00							

190
190
QC
Quality Control

QC21- Final Inspection - Work Order Release

Memo

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00							
0.00							

14-4-17

April-02-14 10:38:36 AM

1 15484

D5076-043

Required Date: 4/16/14

Required Qty: 5.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4441-1		Manufactured	No				f	152.0000		4		DAS 30 9-89	
D4441-1									**				14/64/17
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				152		4			
					86185			152					
Cut qty 1 to 9.4"													
D4441-1		Manufactured	No				f	152.0000		3		DAS 30 9-89	
D4441-1									**				14/64/17
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				152		3			
					86185			152					
Cut qty 1 to 6.4"													
D4441-1		Manufactured	No				f	152.0000		3		DAS 30 9-89	
D4441-1									**				14/64/17
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				152		3			
					86185			152					
Cut qty 1 to 6.7"													
D4441-1		Manufactured	No				f	152.0000		3		DAS 30 9-89	
D4441-1									**				14/64/17
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				152		3			
					86185			152					
Cut qty 2 to 2.6"													
D4441-1		Manufactured	No				f	152.0000		3		DAS 30 9-89	
D4441-1									**				14/64/17
Rubber Seal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST407				152		3			
					86185			152					

Picklist Print

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Work Order ID: 115484

115484

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 5.00

Required Qty: 5.00

D4434-9

Manufactured No

110 Each 2.0000 1 5

DAS

D4434-9

**

30

Bracket

9-89

14/04/11

Location

Loc Qty

Loc Code

GA

2

104612

2

2

D5076-1

Manufactured No

110 Each 0.0000 1 5

DAS

D5076-1

30

Bracket

9-89

14/04/11

D5076-3

Manufactured No

110 Each 0.0000 1 5

DAS

D5076-3

30

Bracket

9-89

14/04/11

D4435-041

Manufactured No

110 Each 1.0000 1 5

**

D4435-041

Bracket Assembly

14/04/17

Location

Loc Qty

Loc Code

ST107

1

96931

1

2

D4441-1

Manufactured No

f

152.0000

DAS

D4441-1

30

Rubber Seal

9-89

14/04/17

Location

Loc Qty

Loc Code

ST407

152

86185

152

1

DAS

30

9-89

Cut qty 1 to 1.7"

14

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Shop Packet Print

Page 2

1941
1942
1943

Picklist Print

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Page 3

Work Order ID: 115484

115484

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 5.00

Required Qty: 5.00

D4441-1

Manufactured No

f

152.0000

2

D4441-1

DAS
30
9-89

Rubber Seal

Location

Loc Qty

Loc Code

ST407

152

86185

152

2

Cut qty 1 to 2.5"

D4440-1

Manufactured No

160

Each

20.0000

1

5

D4440-1

DAS
30
9-89

Grommet

Location

Loc Qty

Loc Code

GA

20

103225

20

5

AN525-832R6

Purchased No

110

Each

223.0000

3

15

AN525-832R6

DAS
30
9-89

Screw

Location

Loc Qty

Loc Code

GA

117

125303

117

6

ST344

106

m127059

106

MS20426AD3-3

Purchased No

110

Each

1,162.000

14

70

MS20426AD3-3

FF 14-04-14

RIVET

Location

Loc Qty

Loc Code

ST334

1162

123352

1162

28

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Shop Packet Print

Page 3

Picklist Print

April-02-14 10:38:36 AM

Page 4

Work Order ID: 115484

115484

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 5.00

Required Qty: 5.00

MS20470AD4-3

Purchased

No

110

Each

5,399.000

15

75

MS20470AD4-3

FF 14-04-14

Rivet - Universal Head

Location

Loc Qty

Loc Code

GA

1516

1642

73

30

2193

1443

ST335

3883

2193

3883

MS21075L08

Purchased

No

110

Each

245.0000

7

35

MS21075L08

FF 14-04-14

ANCHOR NUT

Location

Loc Qty

Loc Code

ST318

245

M126145

45

M128635

200

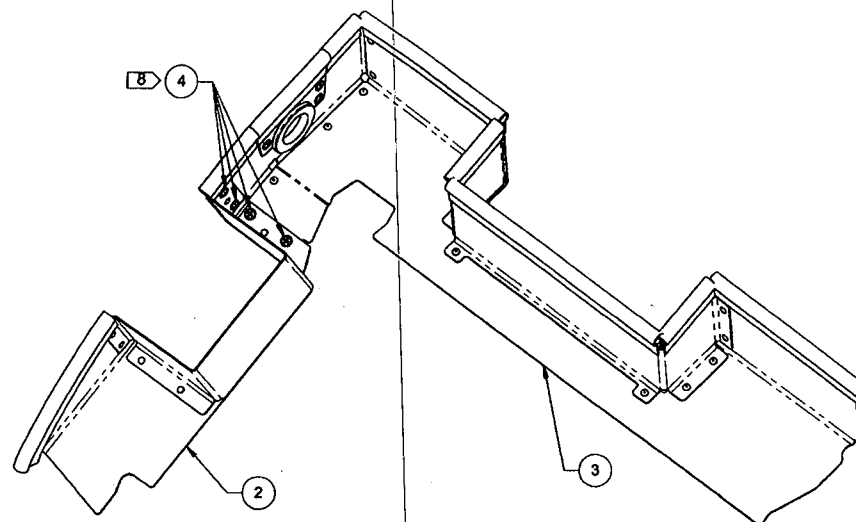
14

April-02-14 10:38:36 AM

Shop Packet Print

Page 4

ITEM	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D5076-041	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-043	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-041 FWD BRACKET ASSEMBLY

NOTES:

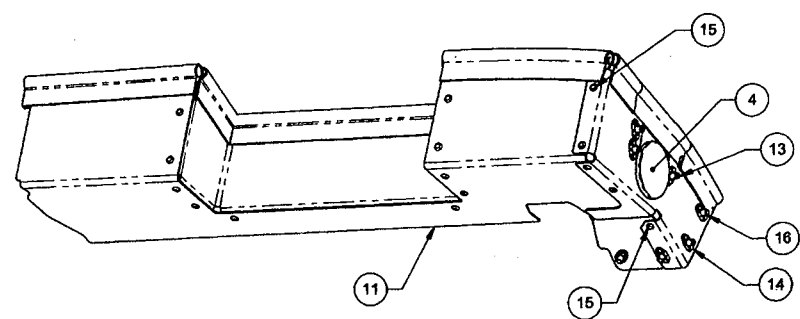
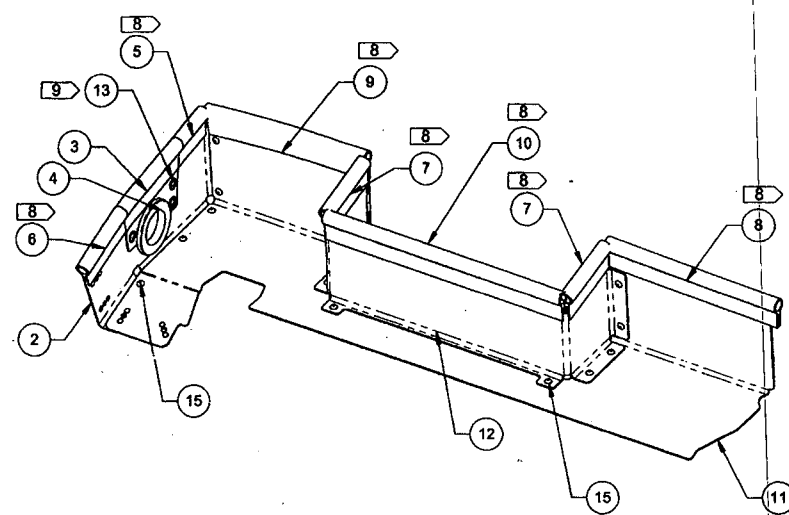
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

115484 MLS
1404-02

RELEASED
2014-03-31

A		NEW ISSUE		RF	14.03.11
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	DC	DRAWING NO.		REV. A	
MFG. APPR.	DD	D5076		SHEET 1 OF 7	
APPROVED	HS	TITLE		SCALE	
DE APPR.	DS	BRACKET ASSEMBLY		NTS	
DATE		14.03.11		<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D5076-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-9	BRACKET
3	1	D4435-041	BRACKET ASSEMBLY
4	1	D4440-1	GROMMET
5	1	D4441-1-017	RUBBER SEAL
6	1	D4441-1-025	RUBBER SEAL
7	2	D4441-1-026	RUBBER SEAL
8	1	D4441-1-067	RUBBER SEAL
9	1	D4441-1-064	RUBBER SEAL
10	1	D4441-1-094	RUBBER SEAL
11	1	D5076-1	BRACKET
12	1	D5076-3	BRACKET
13	3	AN525-832R8	SCREW
14	14	MS20426AD3-3	RIVET
15	15	MS20470AD4-3	RIVET
16	7	MS21075L08	NUT PLATE
17	A/R	3M 1300/1300L	ADHESIVE



D5076-043 FWD INBOARD BRACKET ASSEMBLY

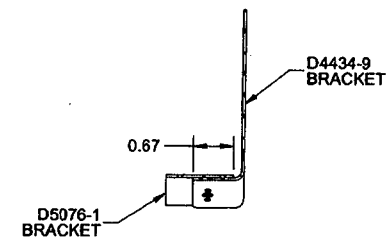
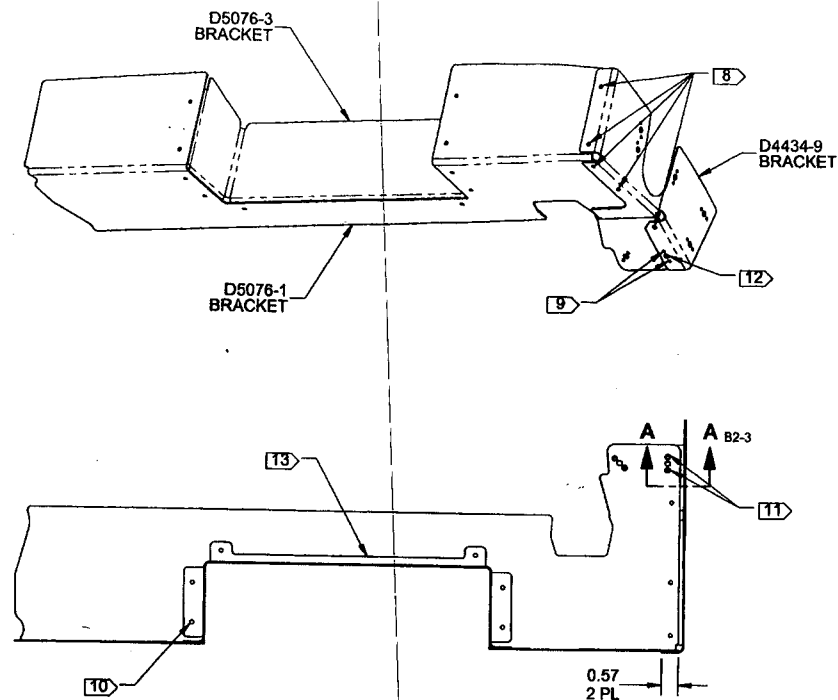
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 PRIOR TO INSTALLING D4435-041.
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE COVER IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

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2014-03-31

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	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5076	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY		
DATE	14.03.11			

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SECTION A-A C4-3

D5076-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

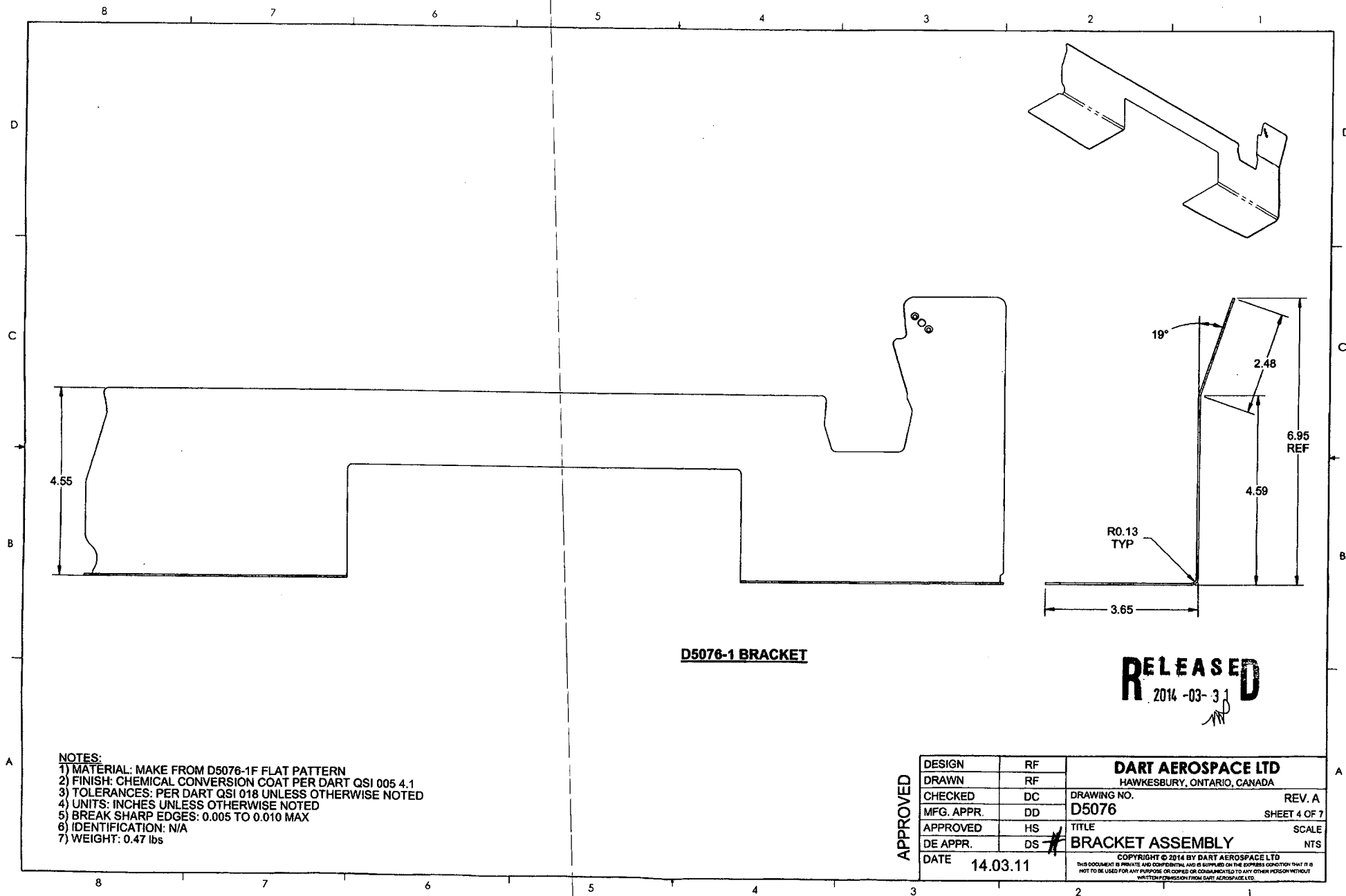
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

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2014-03-31

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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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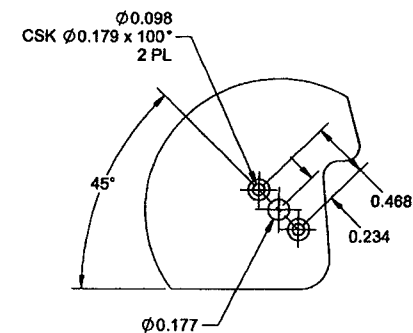
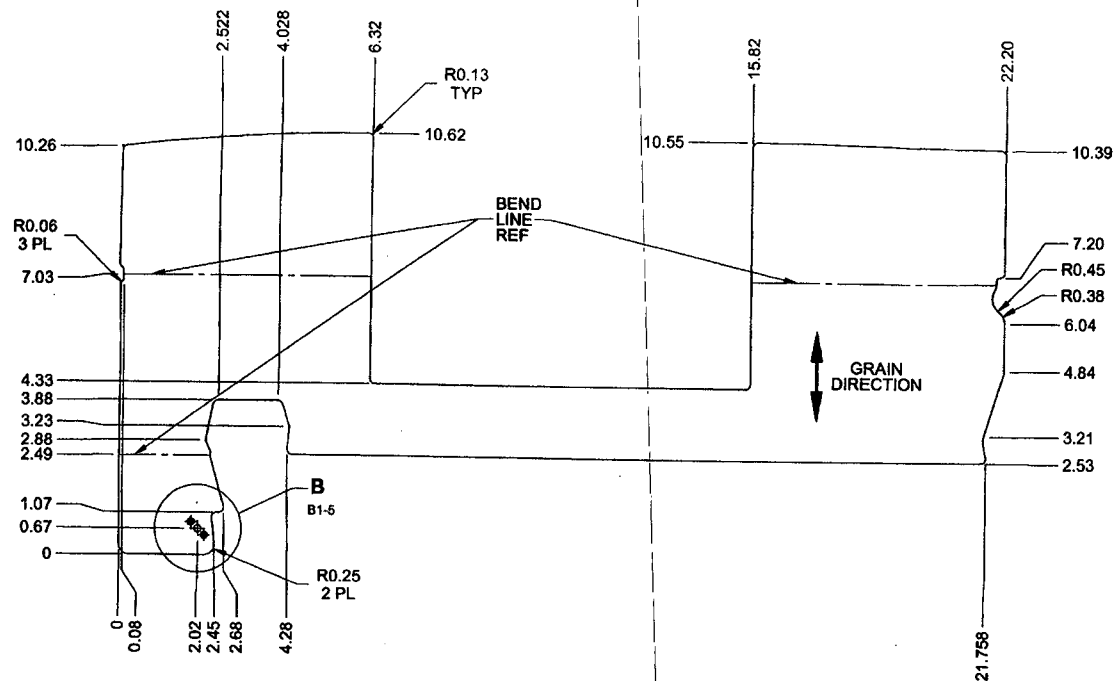
NOTES:

- 1) MATERIAL: MAKE FROM D5076-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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2014-03-31

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
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DETAIL B B7-5

0.040
REF

D5076-1F FLAT PATTERN BRACKET

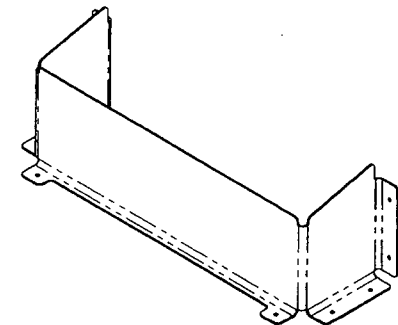
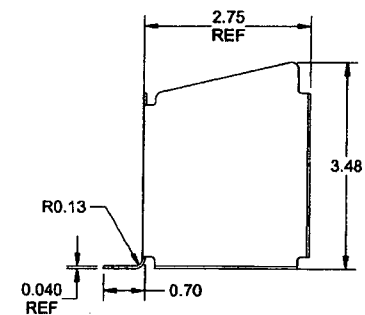
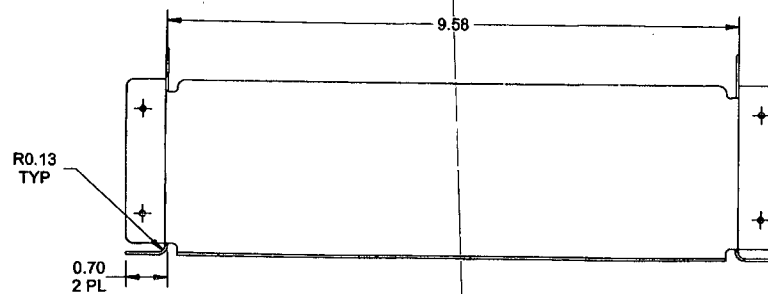
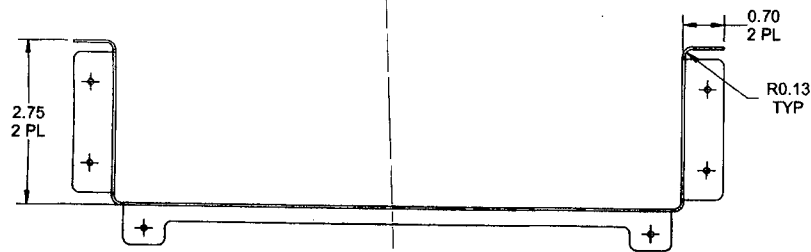
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 5 OF 7
APPROVED	HS	TITLE	SCALE
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D5076-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D5076-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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